

Work Order ID 63703

November 10, 2010 10:54:11 AM

Page 1

Item ID: D212-725-1-233

Accept

Setup Start

Revision ID:

Stop

Item Name: Stiffener Angle

Start Date: 11/10/10 Start Qty: 2.00

Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D212-725-1

F

100

0.00



Small Fab

Memo

0.00

Small Fab

1-Cut as per dwg
2-Make radius as pre dwg and deburr

=> m.h 10/11/15

(2X)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

800016

(12)

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=> H 10/11/17

2 d

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Page 2

Item ID: D212-725-1-233

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Required Date: 11/15/10 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC3- Inspect Part Finish 0.00



QC Memo 0.00

Quality Control

2 10-11-17

140 Identify as per dwg & Stock Location: 386 0.00



Packaging Memo 0.00

Packaging

10/11/17

150 QC21- Final Inspection - Work Order Release 0.00



QC Memo 0.00

Quality Control

10/11/17

MR 10-11-17

Picklist Print

November 10, 2010 10:54:10 AM

Page 1

Work Order ID: 63703

Parent Item: D212-725-1-233

Parent Item Name: Stiffener Angle

Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.10.28 as per dwg revF DD verfec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3A1.0 X 1.0
X.125

Purchased

No

f

12.0000

1

2



2024-T3511 ANGLE 1" X 1" X .125" W



m.p. 10/14/15

X

1.8

Location

Loc Qty

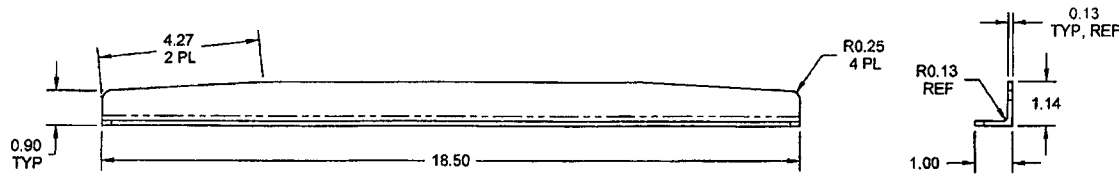
Loc Code

MAT

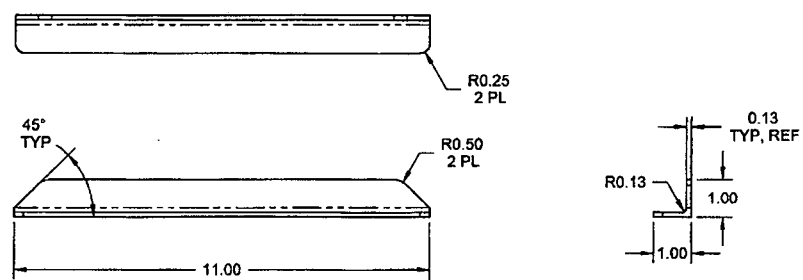
12

116085

12



D212-725-1-231 STIFFENER ANGLE



D212-725-1-233 STIFFENER ANGLE

WLO 63703

RELEASED
07/04/01

- D212-725-1-231/233 NOTES:**
- 1) MATERIAL: 2024-T3511 (QQ-A-200/3F) ANGLE EXTRUSION
 - 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL UPON INSTALLATION
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N D212-725-1-231/-233 USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: N/A

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DS	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D212-725-1	SHEET 81 OF 84
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	212S DETAIL PARTS	NTS
DATE	09.02.02	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries